Work Orde	er ID 78186 10:08:44 AM		*78186*							
Revision ID:	D412-630-032 Pilot/Co-Pilot Step, RH (Folding	g)	Accept	*N900	1040	100)*	Setup Sta	1.71	S1* S2*
Start Date: Required Date: Reference:	02/01/2012 Start Qty: 4. 31/01/2012 Req'd Qty: 4.			Cust Item Customer						
Approvals:	Process Plan: M.C.J QC:	•			Date:			Run Sta Sto	" [V]	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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*120	QC5- Inspect part	completeness to step on W/O	0.00 Sizlo	2/07			4)		
QC Quality Control		nsure tension to retract step is 1 t on aircraft in Eng. lab.	0.00 I to 18 lbs ****	- (-)			RM	· · · · · · · · ·		

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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	NCR: Yes No DQA: Date:						
	Re	solution:	Disposition	n:	QA: N/C Cld	sed:		Date: _				
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)						
DATE	STEP	Description of NC	ļ. <u>.</u> ,	Corrective Action Section		Verific		Approvai	Approval			
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Work Order ID 78186 January-02-12 10:08:44 AM		*781	186*						Page 2
Item ID: D412-630-032 Revision ID:		Accept	*N900	040	100)*	Setup St	art *	VS1*
Item Name: Pilot/Co-Pilot Step, RH (Folding)							S	top *	\\S2*
Start Date: 02/01/2012 Start Qty: 4.00 Required Date: 31/01/2012 Req'd Qty: 4.00 Reference: 31/01/2012 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				•	
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	Re	solution:	Disposition	:	QA: N/C CI	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)					
DATE	STEP	Description of NC		ion B	Verific	cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	tion Sign & Se			Chief Eng	QC Inspector		
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Work Orde				*78	186*							Page 3
Item ID: Revision ID: Item Name:	D412-630-00 Pilot/Co-Pilot	32 Step, RH (Folding)		Accept	*N900	040	100)*	-	Start Stop		S1* S2*
Start Date: Required Date: Reference:	02/01/2012 31/01/2012	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item 1 Customer:	ID:						
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	QC:		Date:	SPC (Y/N):	D	ate:			•	Stop	*N	R2*
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January-02-12 10:08:49 AM

Work Order ID: 78186

78186

Parent Item:

D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP REV. A 05.11.21 IPP REV. B 05.12.19 **NEW ISSUE**

EC

updated pick list EC

IPP REV.C 07.11.12 ecn 1019, nochg EC verifiedby:DD IPP Rev:D 10.05.28 added route seq DD verf:EC

IPP Rev: E 11.06.01

re	removed qty1 an310-4 EC verified by: DD							•					
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Oty Issued	Date Issued	Status
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Work Order ID: 78186

Parent Item:

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

78186 *D412-630-032*

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

No

No

No

Purchased

Purchased

Purchased

115835 ST350 116419 117343 117764 117872 119127 119749

Location

FP001

Each

8.0000 Each

864.0000

Loc Code



Location ST362

117616

Loc Qty 8 130 Each

> 21 11

10

Loc Code

21.0000

Location Loc Qty ST358 118652

Loc Code

W/O:			W	ORK ORDER CHANG	GES				•
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DATE	STEP	Description of NC			ction B	Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	n C	Chief Eng	QC Inspector
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٠	Work Order ID: 78186 Parent Item: D412-630-032 Parent Item Name: Pilot/Co-Pilot Step	o, RH (Folding)		3186* 412-630-0	32*			tart Date: 02/01/2012	Required Date: 31/01/2012
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78186 Work Order ID: 78186 D412-630-032 *D412-630-032* Parent Item: Parent Item Name: Pilot/Co-Pilot Step, RH (Folding) **Start Date:** 02/01/2012 **Required Date:** 31/01/2012 Start Qty: 4.00 Required Qty: 4.00 130 D3454-3 Manufactured Each 20.0000 Location Loc Qty Loc Code ST054 20 20 73348 130_ 22.0000 Each Manufactured Location Loc Qty Loc Code ST054 22 70527 2 20 73343 [130] Manufactured No Each 57.0000 Loc Qty Location Loc Code ST054 57 73302 27 77043 30 130 Manufactured No Each 42.0000 Spacer Location Loc Qty Loc Code ST054 42 14 28

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Picklist Print January-02-12 10:08:49 AM								Page 5
Work Order ID: 78186		*7	8186*					
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Parent Item Name: Pilot/Co-Pilot S	tep, RH (Folding)	1 /	/ 4 <i>/</i> =(),)()=(1.12		Start Date: 02/01/2012	Required Date: 31/01	/2012
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Work Order ID: 78186

Parent Item:

Purchased

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

78186 *D412-630-032*

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

NASI515H5

No

Each

109.0000

Loc Code

Spacer

Manufactured No Location Loc Oty FG 40 103286 20 103691 20 ST277 69 69 103286 110 Each

57.0000

Strut Weldment Assembly

Manufactured No

Loc Qty Location ST054 57 73302 27 77043 30 110 Each

3.0000

Loc Code

Loc Code

Step Weldment Assembly

Manufactured No Location Loc Qty ST198A 3 72027 3 110 Each

0.0000

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Picklist Print - January-02-12 10:08:49 AM								Page
Work Order ID: 78186		*7	8186*					
Parent Item: D412-630-032			412-630-0	132*				
Parent Item Name: Pilot/Co-Pilot St	ep, RH (Folding)	•				S	tart Date: 02/01/2012	Required Date: 31/01/2012
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D3443-9							**	-
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DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Description		n B Sign 8	Verific Section		Approval Chief Eng	Approval QC Inspector
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January-02-12 10:08:49 AM

Work Order ID: 78186

78186

Parent Item:

D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Required Qty: 4.00

No Purchased

Manufactured

Purchased

Manufactured

No

No

110

32.0000

Each

10 20

Each

Start Qty: 4.00

**

AN4CH3

SS Bolt

AN4CH3

Location Loc Qty Loc Code ST357 32 117616

118131

21.0000

D3465-1

D3465-1

Location Loc Qty Loc Code ST054

110

46134 73449

21 20 130 Each

28.0000

M120 124

Location ST344 119328 119799

Loc Qty 28 13 15 110 Each Loc Code

0.0000

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W/O:			V	ORK ORDER CH	IANGES				****	+
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Work Order ID: 78186

78186

Location

ST054

Parent Item:

D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Oty: 4.00

Required Oty: 4.00

D3454-7

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D3454-7

Manufactured No 110

22.0000 Each

Loc Code

 $\left(\begin{array}{cc} 2 \end{array}\right)$

Purchased No

Loc Qty 22 70528 2 73346 20 110 Each

36.0000

**

AN310-7

Location Loc Oty Loc Code ST344 36 1<u>14784</u> 119749 26 10

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		WC	RK ORDER CHANG	BES					•							
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D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

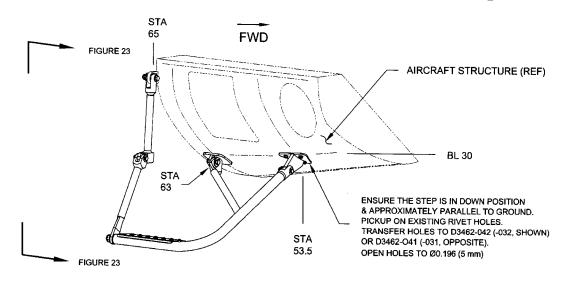


FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

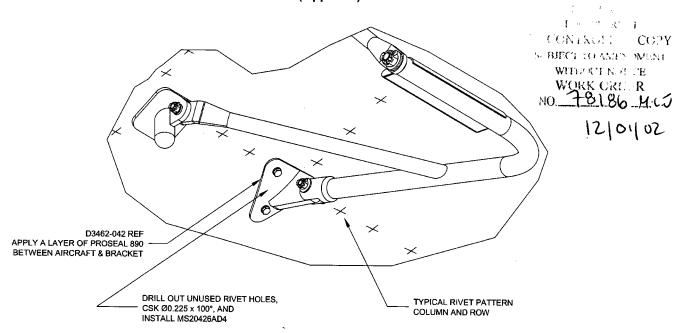


FIGURE 22 - Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

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W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approvar	
								1 1 93 mg.	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	4.704
	Re	solution:	Dispositio	n:	QA: N/C Cld	osed:		Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC Corrective Action			ion B	VARITICATI			Approval
DAIL	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	Section C	Approval Chief Eng	QC Inspector	
									=
•									
•									

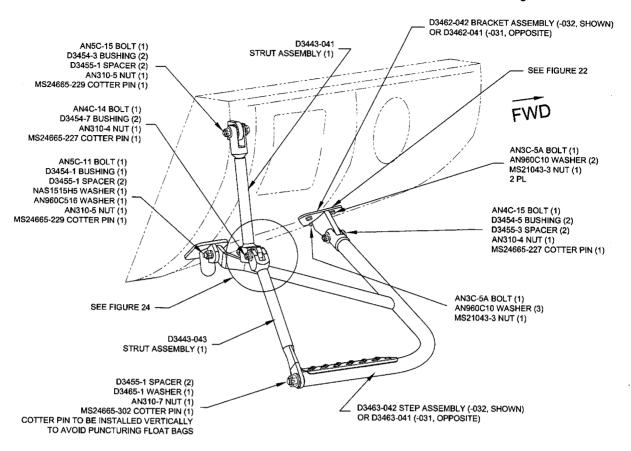


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

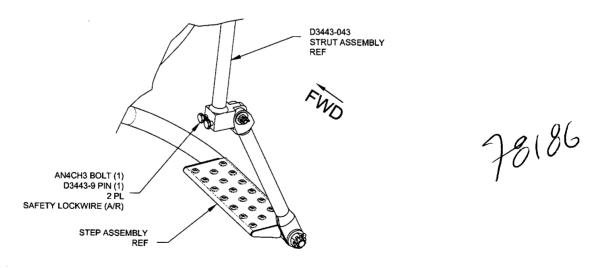


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH,Pilot/Co-Pilot Folding-Step Installation (Shown) D412-630-031 LH (Opposite)

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Date: 08.12.12

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	. Johnor	<i></i>							
W/O:			WC	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	_								
′ -									
							-		
• •									
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Dispositio	QA: N/C CI	QA: N/C Closed:			Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section			Verific		Approval	Approval QC Inspector
DATE SIEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Chief Eng	
									1
-									

REFERENCE ONLY

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Qty -031	, Qty ∖-032	Part Number	Description
Х		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	Х	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	. 1	D3443-041	STRUT ASSEMBLY_
1 1	1	D3443-043	STRUT ASSEMBLY .
2 (2	D3443-9	PIN ^r
1 7	1	D3454-1	*BUSHING.)
2	2	D3454-3	BUSHING
2,	2	_D3454_5	"BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER1
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
1	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	3 2	AN310-4	
2		AN310-5	NUT=4
1	1 1	AN310-7	NUT
3		AN3C-5A	BOLT
1		AN44-C12	* EYEBOLT
1 ;		AN4C14	BOLT 5
1 :	2 1	AN4C15	BOLT
2	<u></u> 2	AN4CH3	BOLT T
1)	1	AN5C11	ĽBOLT,
1 ,	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1 '	1	_AN960C516	WASHER ,
3	3	MS21043-3	NUT /
2 \	2 2	MS24665-227	COTTER PIN ,
2	2	MS24665-229	COTTER PIN
1	1_1_	MS24665-302	COTTER PIN
1	į 1	NAS1515H5	WASHER!

^{*} USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034[™] HELI-ACCESS-STEP

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